

Work Order ID 111012

January-08-14 12:51:48 PM

111012

Page 1

Item ID: K10003 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 1/08/14 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 1/08/14 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 14-01-10 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
IIN634,635	G	

100	DOCUMENT CONTROL	0.00	DAS						
100			27						
DC	Memo	0.00	9-89						
Document Control	Create White labels only per PPP K10003	CHG 0010	14/5/22						

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00	DAS						
120			27						
QC	Memo	0.00	9-89						
Quality Control			14/5/22						



DAS
33
14-05-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 111012

111012

Page 2

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Item ID: K10003

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle

Start Date: 1/08/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/08/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location:

PK 14

0.00

130

Packaging

Memo

0.00

Packaging

2

MAY 26 2014

DAS
06
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 14-05-26

14-05-26

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 111012

Parent Item: K10003

Parent Item Name: Saddle

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP : J 06-07-25 As per DSI 9344 JLM
 IPP : K 06.11.17 Per K10003 Rev C KJ
 IPP : L 07.01.12 Document Record for copying bluefile rmv KJ
 IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:
 IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev:O 11.03.11 per dsi9536
 DD verf:EC IPP REV:P 12.01.23 AS PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-51A Bolt		Purchased	No			110	Each	165.0000	8	128978	16	DAS 33 9-89	DAS 33 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		5							
				122993		5							
				ST360		35							
				m127363		35							
				ST517		125							
				m127410		50							
				m127817		75							
AN4-6A BOLT		Purchased	No			110	Each	1,356.0000	16	128634	32	DAS 33 9-89	DAS 33 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST355		250							
				M127410		250							
				ST514		1106							
				M126317		856							
				M127817		250							
AN4C46A Bolt		Purchased	No			110	Each	23.0000	4	128227	8	DAS 33 9-89	14-05-21
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST		2							
				123642		2							
				ST359		21							
				m127061		21							

Shp 27

Shp 27

Shp 27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 111012
Parent Item: K10003
Parent Item Name: Saddle

Start Date: 1/08/14
Start Qty: 2.00

Required Date: 1/08/14
Required Qty: 2.00

AN6-12A

Bolt

Purchased No

110 Each 281.0000

8

16

DAS

33

9-89

DAS

08

9-89

Location

Loc Qty

Loc Code

ST339

8

M122151

8

ST504

225

M127432

100

M127817

125

127817

ST516

48

M126105

48

D2570

Bushing

Manufactured No

110 Each 604.0000

24

48

DAS

33

9-89

Location

Loc Qty

Loc Code

FG

12

88781

12

7

ST011

592

100371

88

100870

122

102439

79

106589

7

108538

196

109479

60

110176

40

108538

D2571

Saddle, Fwd, Out

Manufactured No

110 Each 27.0000

0

2

DAS

33

9-89

Location

Loc Qty

Loc Code

ST441

27

104701

7

105995

1

108297

7

109923

12

115594

14-0524

January-08-14 12:51:47 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

January-08-14 12:51:47 PM

Page 3

Work Order ID: 111012

Parent Item: K10003

Parent Item Name: Saddle

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 2.00

Required Qty: 2.00

D2572
Saddle, Fwd, In

Manufactured No

110 Each 30.0000

113893² DAS 33 9-89

Location

Loc Qty

Loc Code

ST441 30
105572 1
106514 5
108485 12
109924 12

SWP 27

D2573
Saddle, Aft, Out

Manufactured No

110 Each 20.0000

115872² DAS 33 9-89

Location

Loc Qty

Loc Code

ST442 20
105413 4
108126 4
108525 12

SWP 27

D2574
Saddle, Aft, In

Manufactured No

110 Each 16.0000

113895² DAS 33 9-89

Location

Loc Qty

Loc Code

ST442 16
106416 6
108523 10

SWP 27

D2747
Set Screw

Manufactured No

110 Each 247.0000

8 14-05-21

Location

Loc Qty

Loc Code

ST017 247
106173 60
110232 100
86827 86
99355 1

DAS 27 9-89

110232² DAS 33 9-89

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 4

Work Order ID: 111012

Parent Item: K10003

Parent Item Name: Saddle

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 2.00

Required Qty: 2.00

D2876
Saddle Spacer

Manufactured No

110 Each 55.0000

2 110146 DAS 33 9-89 06 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST020
106074
108425

55
28
27

D2877
Saddle Spacer

Manufactured No

110 Each 55.0000

2 110301 DAS 33 9-89 06 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST020
103013
106231
108487

55
2
27
26

D3405-041
Gh Lug

Manufactured No

110 Each 23.0000

1 113925 DAS 33 9-89 06 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST468
108258
108437
109490

23
1
12
10

D3405-043
Gh Lug

Manufactured No

110 Each 34.0000

1 2 DAS 33 9-89 14-05-27

DAS 27 9-89

Location

Loc Qty

Loc Code

ST461
107261
ST468
105544
108792

16
16
18
2
16

107261

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 111012

Parent Item: K10003

Parent Item Name: Saddle

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 2.00

Required Qty: 2.00

D3407-041

Tow Ring

Manufactured No

110 Each 21.0000

1

113600

DAS
33
9-89

DAS

06

9-89

Location

Loc Qty

Loc Code

ST444

3

107840

3

ST463

18

107954

6

108404

4

109405

8

DAS
27
9-89

27

D3417-3

Washer

Manufactured No

110 Each 173.0000

2

4

DAS
33
9-89

DAS

06

9-89

Location

Loc Qty

Loc Code

ST042

173

106851

52

109130

1

109747

20

109907

100

DAS
27
9-89

27

106951

D3456-1

Washer

Manufactured No

110 Each 128.0000

1

113126

DAS
33
9-89

DAS

06

9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST046

121

103539

1

103787

25

107629

17

109751

78

DAS
27
9-89

27

D3533-1

Set Screw

Manufactured No

110 Each 114.0000

2

4

DAS 14-05-20
33
9-89

DAS

06

9-89

Location

Loc Qty

Loc Code

ST054

114

102438

114

105438

DAS
27
9-89

27

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Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 6

Work Order ID: 111012

Parent Item: K10003

Parent Item Name: Saddle

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 2.00

Required Qty: 2.00

MS2104214

Locknut

Purchased

No

110 Each 5,431.0000

24

48

DAS
33
9-89

DAS
33
9-89

128300

Location

Loc Qty

Loc Code

GA 80
m126333 80
ST509 4000
m127255 2000
m127813 2000
ST518 1351
m127376 1351

DAS
27
9-89

27

MS210434

Nut

Purchased

No

110 Each 676.0000

5

10

DAS
33
9-89

128300

Location

Loc Qty

Loc Code

FG 40
104603 40
GA 58
125807 58
ST509 578
m127255 578

DAS
27
9-89

27

NAS1149D0463J

WASHER

Purchased

No

110 Each 1,400.0000

32

64

DAS
33
9-89

128591

Location

Loc Qty

Loc Code

ST510a 1400
M127813 1400

DAS
27
9-89

27

NAS1149D0663J

Washer

Purchased

No

110 Each 2,186.0000

8

16

DAS
33
9-89

127916

Location

Loc Qty

Loc Code

ST294 487
M126284 487
ST510a 1699
M126334 699
M127813 1000

DAS
27
9-89

27

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